



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5380-1
Job Sheet 179832



DAS
21
9-88

Part No: D5380-1

Job Qty: 4 ea **6 ea**

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/22/18

Job Tracking No:

Due Date: 7/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV C SHEET 1 IPP REV.A NEW ISSUE JFS 16/02/02 VERIFIED BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		7/31/18	0.00	0.00	Start Up Machining-4		18/7/30
100	CNC Vertical Machining	4 pcs		7/31/18	0.73	13.79	HAAS1-2		18/7/30
110	QC	4 pcs		7/31/18	0.00	0.00	QC2 Machining-4		18/7/30
120	QC	4 pcs		7/31/18	0.00	0.00	QC8 Machining-4		18/7/30
121	QC	4 pcs		7/31/18	0.00	0.00	QC5		18/08/08
130	Packaging	4 pcs		7/31/18	0.00	0.00	Packaging3-2		18-08-08
140	QC21-SA	4 Ea		7/31/18	0.00	0.00	QC21		

Part Op 100 - Machine as per Folio FB458
Descriptions: 130 - LOCATION : LG056 **056**

DAS
21
9-88

AUG 09 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5380-1TRN	Support Turning Detail	2 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D5380-1TRN	2	3	0

5069641

Part Specifications

Specifications could not be found.

Plex 6/22/18 11:30 AM dart.lacelle.linda



Dart Aerospace Ltd.
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Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S097633



Part: D5380-1

Job No: 179832

Serial No/Batch: S097633

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/30/18

no

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																													
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																																																											
Description Work Order Deviation			Disposition																																																																												
			Completed By																																																																												
			Lead hand / Supervisor Approval Verification																																																																												
			QC / QA Coordinator Approval																																																																												
<table border="1" style="width:100%; border-collapse: collapse;"> <thead> <tr> <th colspan="3" style="text-align: left;">Root Cause</th> <th colspan="3" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">No Re-verification ☐</td> <td style="width:15%;">Pressure/Forced ☐</td> <td style="width:15%;">Temperature/Cure ☐</td> <td style="width:15%;">Power Loss/Surge ☐</td> <td style="width:15%;">Positioned Wrong ☐</td> </tr> <tr> <td>Design ☐</td> <td>Operator ☐</td> <td>Bending ☐</td> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>Doc/Data ☐</td> <td>Offset/Setup ☐</td> <td>Centre Not Concentric ☐</td> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Equip/Tooling ☐</td> <td>Supplier ☐</td> <td>Cracks ☐</td> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Handling/Pre ☐</td> <td>Training ☐</td> <td>Crimp/Kink/Ripple/Wave ☐</td> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Material ☐</td> <td>Use for Testing ☐</td> <td>Cuffs ☐</td> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Internal Transport ☐</td> <td>Poor Information ☐</td> <td>Crushing ☐</td> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Tribal Knowledge ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Product Improvement ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Substation ☐</td> <td>Process Improvement ☐</td> <td>Marks/Chatter ☐</td> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> <tr> <td>Past Expiry Date ☐</td> <td>Manufacturing Process ☐</td> <td colspan="4" rowspan="2" style="text-align: center; vertical-align: top;">OTHER : _____</td> </tr> <tr> <td>Misidentified ☐</td> <td>Past Due ☐</td> </tr> </tbody> </table>						Root Cause			FAULT CATEGORY			Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____				Misidentified ☐	Past Due ☐
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DART AEROSPACE LTD		Work Order:	
Description: Support		Part Number:	D5380-1
Inspection Dwg: D5380 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	3.890	3910		3.902	3.901	3.900	3.898	
AB	0.256	0.263		0.256	0.256			
AC	3.540	3.560		3.550	3.550	3.551	3.549	
AD	1.765	1.785		1.775	1.775	1.775	1.775	
AE	0.590	0.610		0.600	0.600	0.600	0.600	
AF	1.140	1.160		1.150	1.149	1.150	1.150	
AG	2.290	2.310		2.299	2.299	2.298	2.298	
AH	3.550	3.560		3.554	3.554	3.551 ^s	3.551 ^s	
AI	0.625	0.630		0.625	0.625	0.625	0.625	
AJ	0.528	0.548		0.539	0.538 ^s	0.538	0.538	
AK	0.498	0.518		0.503	0.499	0.506	0.506	
AL	0.494	0.514		0.499	0.495	0.500	0.503	
AM	1.094	1.114		1.099	1.095	1.102	1.102	
AN	0.220	0.222		0.221		0.221	0.221	
AO	0.490	0.510		0.500	0.500	0.501	0.501	
AP	1.250	1.270		1.263	1.263	1.264	1.263	
AQ	2.465	2.485		2.476	2.475	2.479	2.475	
AR	1.405	1.425		1.414	1.414	1.415	1.415	
AS	0.050	0.110		0.070	0.070	0.070	0.070	
AT	0.300	0.360		0.335	0.331	0.325	0.325	
AU	0.100	0.125		0.1125	0.111	0.112	0.112	
AV	0.220	0.280		0.250	0.250	0.250	0.250	
AW	0.030	0.090		0.060	0.060	0.060	0.060	
AX	0.010	0.030		0.020	0.020	0.020	0.020	
AY	0.115	0.135		0.125	0.125	0.125	0.125	
AZ	0.640	0.660		0.650	0.650	0.650	0.650	
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:		Date:	
Audited by:	<i>mmk</i>	Date:	18/08/08
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	
Description: Support		Part Number:	D5380-1
Inspection Dwg: D5380	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	15	16	3	4	5
HAAS Section								
AA	3.890	3910		3.899	3.902			
AB	0.256	0.263		0.257	0.257			
AC	3.540	3.560		3.554	3.54			
AD	1.765	1.785		1.775	1.775			
AE	0.590	0.610		0.605	0.605			
AF	1.140	1.160		1.150	1.150			
AG	2.290	2.310		2.302	2.302			
AH	3.550	3.560		3.551	3.551			
AI	0.625	0.630		0.625	0.625			
AJ	0.528	0.548		0.538	0.538			
AK	0.498	0.518		0.508	0.508			
AL	0.494	0.514		0.504	0.504			
AM	1.094	1.114		1.104	1.104			
AN	0.220	0.222		0.221	0.221			
AO	0.490	0.510		0.501	0.501			
AP	1.250	1.270		1.261	1.261			
AQ	2.465	2.485		2.472	2.473			
AR	1.405	1.425		1.415	1.415			
AS	0.050	0.110		0.070	0.070			
AT	0.300	0.360		0.33	0.33			
AU	0.100	0.125		0.112	0.112			
AV	0.220	0.280		0.25	0.250			
AW	0.030	0.090		0.06	0.06			
AX	0.010	0.030		0.02	0.02			
AY	0.115	0.135		R.125	R.125			
AZ	0.640	0.660		R.650	R.650			
Ensure that Ø " bore is perpendicular to " bore within "								
Accept/Reject								

Measured by:		Date:	
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Audited by: <i>smc</i>	Date: <i>18/08/14</i>
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	17.01.31	New Issue	KJ	<i>[Signature]</i>